

Date: Wednesday, 11/21/2007 2:41:47 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ARMOR SHIELD  
 Job Number : 35955  
 Estimate Number : 12380  
 P.O. Number : N/A Part Number : D407667205A  
 This Issue : 11/21/2007 S.O. No. : N/A Drawing Number : DSI9326  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : LANDING GEAR Drawing Revision : A  
 Previous Run : 33498 Material : N/A  
 Due Date : 11/28/2007 Qty: 1 Um: Each  
 Written By : JA 07.11.21  
 Checked & Approved By : JA 07.11.21  
 Comment : Est Rev: A New Issue 06-04-19 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD407-667-205A CHG002  
 Add DSI 9326 to existing paper work. 003 n 7/11/30

2.0 D407667205 AFT Crosstube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

~~AFT~~ Fwd Crosstube

Batch: 33327

07.11.22

3.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Remove tube from packaging

2-Apply Armor shield as per DSI 9326

A/R Armor Shield Batch: 106053

07.11.22

4.0 QC14 INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

①

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-667-205A


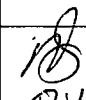
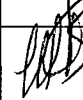

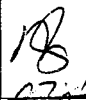








Location: B

PPP Rev: B

07.11.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D407-66-205A PAR #: N/A Fault Category: Prod Finishing NCR: Yes No DQA: D Date: 01/11/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 35755		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/11/26	#30	During inspection foreign objects (Dirt/Dust/marks) were found under the Armor shield.	 07/11/26	Strip all Armor shield with	BT 07-11-28	 07-11-28		 07/11/26
				Re prime and paint with Epoxy as per QSI 005	BT 07-11-28	 07-11-28		
		R.C. Hummer error/take wasnt cleaned before applying		*Inspect QCI #14	N/A	 07-11-28		 07/11/26
				*CLEAN AND APPLY ARMOR SHIELD (BA 106053) AS PER QSI 005	BT 07-11-28	 07-11-28		
				Reinstall Apertures strips <del>BA</del> D2856-400-773 BA 5442 and chamber shield. D3190-1 BA NA and	BT 07-11-28	 07/11/28	 07/11/28	 07/11/28

NOTE: Date & initial all entries

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User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARMOR SHIELD

Job Number: 35955

Part Number: D407667205A

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Don't 30*

Job Completion



*W Still 30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART SERVICE INSTRUCTION

To further protect Dart crosstubes from mechanical damage in service, they may be treated with "Armor Shield" surface treatment. To designate crosstubes with 'Armor Shield' add 'A' to the Part Number. For example, D206-667-101A is a D206-667-101 crosstube coated with Armor Shield. The Change Number of Dart crosstubes with "Armor Shield" is affected as per above table. It is acceptable to apply the Armor Shield in regions shown in Figure 1 or Figure 2 only. It is **NOT** acceptable to apply Armor Shield in the cuff and support/clamp regions.

INSTALLATION	STC		CHANGE NUMBER	
	CANADIAN	FAA	DSI 9326 REV. A (Proform PF746/746-1 Treatment)	DSI 9326 REV. B (BCG4 Treatment)
D205-596-101A/-103A/-105/-107A	SH03-6 ISSUE 3	SR01742NY	CHG 001	CHG 002 (or later)
D212-664-101A/-201A D412-664-203A D412-664-105A/-205A	SH01-9 ISSUE 3	SR01298NY	CHG 002 (or earlier) CHG 004 (or earlier) N/A	CHG 003 (or later) CHG 005 (or later) CHG 001 (or later)
D206-667-101A/-103A/-201A/-203A D407-667-105A/-205A	SH01-5 ISSUE 3	SR01304NY	CHG 001 CHG 002 (or earlier)	CHG 002 (or later) CHG 003 (or later)
D058-676-101A/-201A	N/A	SR01018SE	CHG 001	CHG 002 (or later)
D350-748-101A/-201A	SH06-27 ISSUE 1	SR02359NY	N/A	CHG 001 (or later)

## 1.0 TO APPLY ARMOR SHIELD

- 1.1 Ensure the crosstube is appropriately finished in accordance with the relevant manufacturing drawing or Instruction for Continued Airworthiness (ICA).
- 1.2 Clean/degrease surface of crosstube using Methyl Ethyl Ketone (MEK), 4105S Wash'n'Wipe Degreaser, or equivalent and wipe the surface to clean the entire area
- 1.3 Mask areas around supports and cuffs per Figure 1 or Figure 2 (D350-748-101/-201 only). Abrade paint finish in areas requiring protection using 800 grit sandpaper. Ensure the surface is de-glossed.
- 1.4 Re-clean the surface per Step 1.2.
- 1.5 Mix BCG4 Component A and BCG4 Component B in accordance with manufacturer's instructions.
- 1.6 Apply 5 wet coats in accordance with manufacturer's instructions.
- 1.7 To avoid hard tape line, unmask immediately after application of last coat.
- 1.8 Allow BCG4 to dry in accordance with manufacturer's instructions.

## 2.0 ARMOR SHIELD REMOVAL / RE-APPLICATION

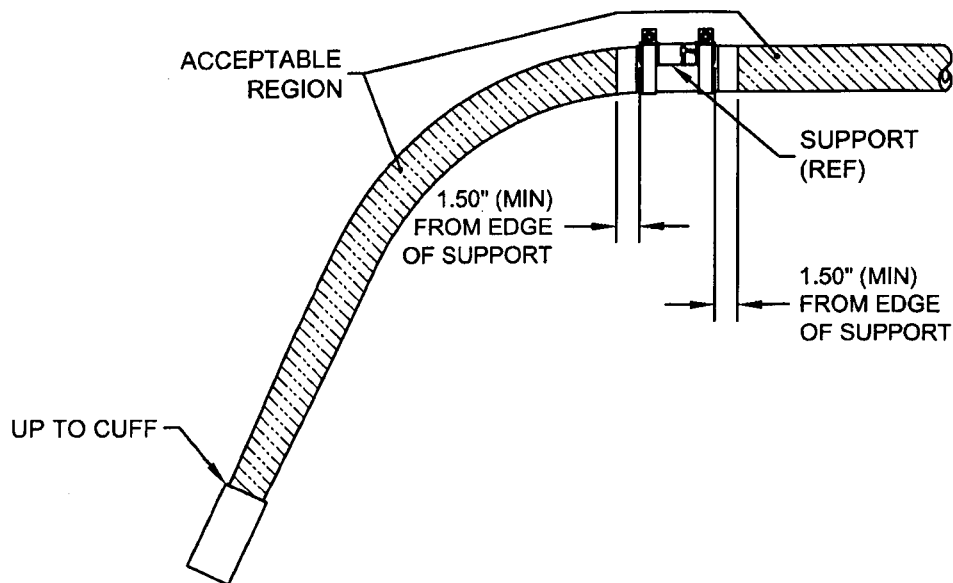
To remove the Armor Shield coating or if damage to the coating and/or crosstube is observed during inspection.

- 2.1 Remove Armor Shield from the affected area using 80 grit sandpaper. To remove Armor Shield from larger areas, bead blasting has been determined to be the most effective technique.
- 2.2 Repair mechanical damage (within limits) to the crosstube and touch up finish in accordance with the relevant ICA.
- 2.3 Apply Armor Shield in accordance with Section 1.0 of these instructions.

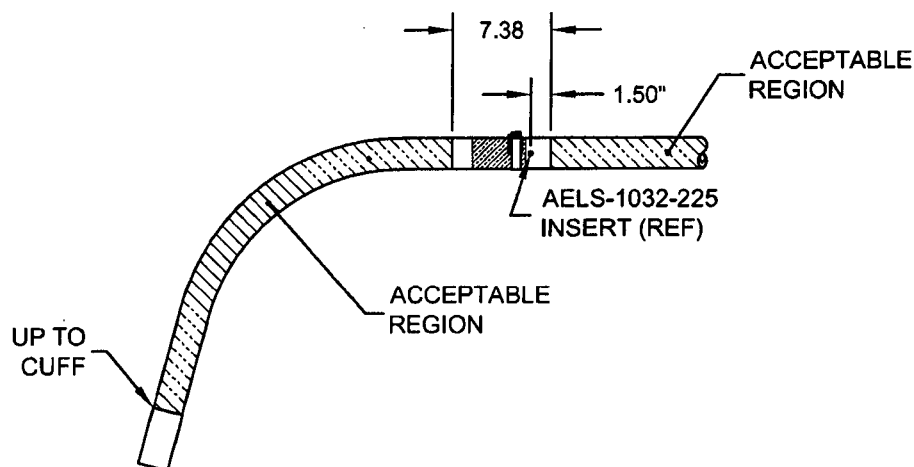
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: 	
D. SHEPHERD (DE # 02)	
DATE:	07.10.17
CERT. NO.:	SEE TABLE
ISSUE NO.:	SEE TABLE

B	BCG4 REPLACES DISCONTINUED PROFORM PF 746 OR PF 746-1; ADD D350-748-101/-201	MB	07.10.17
A	NEW ISSUE	PH	06.02.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. REV. B DSI 9326 SHEET 1 OF 2  TITLE SCALE ARMOR SHIELD NTS  <small>COPYRIGHT © 2006 BY DART AEROSPACE LTD                  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	PH		
CHECKED	PH		
MFG. APPR.	EE		
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DE APPR.	PH		
DATE	07.10.17		

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**FIGURE 1 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD**  
(SEE FIGURE 2 FOR D350-748-101/-201 CROSSTUBES)



**FIGURE 2 - ACCEPTABLE REGIONS TO BE COATED WITH ARMOR SHIELD**  
(D350-748-101/-201 ONLY)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.10.17  
CERT. NO.: SEE TABLE  
ISSUE NO.: SEE TABLE

DESIGN	<i>PH</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>PH</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>PH</i>	DSI 9326	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ARMOR SHIELD	NTS
DATE	07.10.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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